

Work Order ID 139044

139044

Page 1

Friday, November 13, 2015 11:21:39 AM

Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 11/13/2015 Start Qty: 25.00 ***25*** Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 25.00 ***25*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date **NOV 17 2015** Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4775	C ☒

110	Pick Kit	0.00							
110	Large Fab								
Packaging	Memo	0.00							
Packaging									

120		0.00							
120									
Small Fab	Memo	0.08							
Small Fab	1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG								
	A/R PROSEAL BATCH: <u>133071</u>								
	2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)								

NOV 30 2015

25/88 DEC 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130						<u>25</u>			DAS 38 9-89
QC	Memo	0.01							
Quality Control									DEC 02 2015
140	Identify as per dwg & Stock Location: <u>St 514</u>	0.00							
140						<u>25</u>			DAS 8 9-89
Packaging	Memo	0.00							DEC 02 2015
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									15/12/2015
QC	Memo	0.04							
Quality Control									

MCS DEC 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

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Page 1

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	6.0000	1	25			
D4775-1													
Strut Tube													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			6						
					137319		6						
D4777-1		Manufactured	No			110	Each	25.0000	1	25			
D4777-1													
Rod End Bearing													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST125			25						
					137188		1						
					137679		6						
					138047		18						
D4776-1		Manufactured	No			110	Each	0.0000	1	25			
D4776-1													
Basket Strut Clevis													
D4776-5		Manufactured	No			110	Each	7.0000	4	100			
D4776-5													
Spacer													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST125			7						
					137338		7						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
3				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

Picklist Print

Friday, November 13, 2015 11:21:38 AM

Work Order ID: 139044

139044

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 25.00

Required Qty: 25.00

AN3-10A Purchased No

110 Each 107.0000 2 50

AN3-10A

133694

DAS
6
9-53

Location	Loc Qty	Loc Code
GA	72	
m132763	72	
ST349	35	
m133234	35	

MS21042L3 Purchased No

110 Each 579.0000 2 50

MS21042L3

FF

DEC 01 2015

Nut

Location	Loc Qty	Loc Code
FP001	300	
M130922	300	
GA	90	
M131317	90	
ST304	189	
M133498	189	

50

MS21209-F615 Purchased No

110 Each 57.0000 1 25

MS21209-F615

Heli-Coil

Location	Loc Qty	Loc Code
GA	7	
m131270	2	
m132164	5	
ST296	50	
m133483	30	
m133577	20	

25

NOV 30 2015 P.T.O.
9-53 DAS
6
9-53

DQA:

Date: DEC 01 2015



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 11/02/04

Work Order update only ☐

Work Order: <u>139044</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>MS21209 F615</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>16-5574</u>		Scrap ☒		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>DEC 03 2015</u>		Step #: <u>120</u>		QTY Effective: <u>(3) pcs.</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			DAS 9 9-89 DEC 03 2015		
3 Heli-coils Replaced MS21209 F615 M 133577 When inserting Heli-coil pin on Heli-coil opened up an Tool went right through it replaced MS21209 F615 - M 133483 with MS21209 F615 - M 133577 RC Operator				Scrap and Replace MS21209-F615 x 3			Completed By F.F. DEC 01 2015		
							Lead hand / Supervisor Approval Verification DAS 30 9-89 DEC 01 2015		
							QC / QA Coordinator DAS Approval 9 9-89 DEC 03 2015		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Set-up ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☒	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							